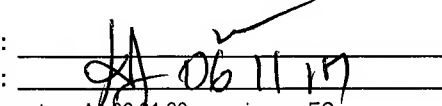
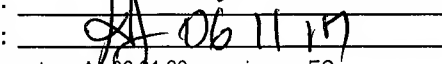


Date: Friday, 11/17/2006 9:08:11 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG WELDMENT
<b>Job Number</b> : 29516	
<b>Estimate Number</b> : 12116	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D335313
<b>This Issue</b> : 11/17/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3353 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 28328	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 12/5/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : est rev A 06.01.26 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M1018TR1250W109	1010-1025 Steel Tubing
-----	-----------------	------------------------



**Comment:** Qty.: 0.9188 f(s)/Unit Total : 3.6750 f(s)

AISI 1018-1025 mild steel seamless round tubing

1.250" od X 0.109" wall

batch: M100843

Cpl 07.01.04

(4)

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW

Cut blank 10.50" long as per dwg D3353

CPL 07.01.04

(4)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE

1- Drill & tap as per dwg D3353

2-Deburr as per dwg D3353

Cpl 07.01.04

(4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

M 07/01/04

(4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: W523

Cpl 07.01.04

(4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: LD Date: 07/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/17/2006 9:08:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 29516

Part Number: D335313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④  
D 07/01/08

Job Completion



U 07/01/05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

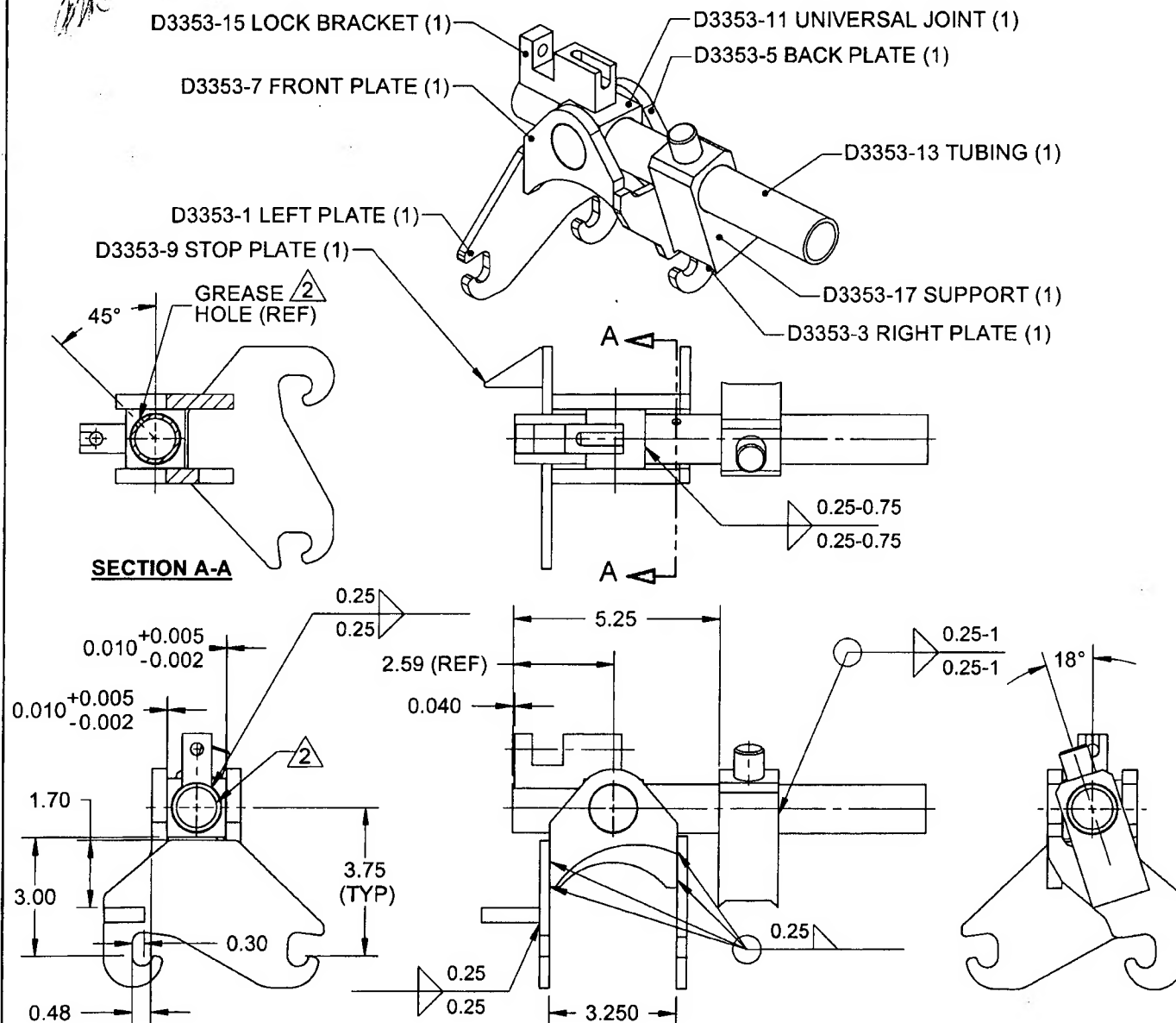
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE <b>04.12.14</b>		TITLE <b>LUG WELDMENT</b>	SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED  
26/02/09



**D3353-041 LUG WELDMENT**

**NOTES:**

- 1) WELD PER DART QSI 004  
2) COVER INSIDE HOLES PRIOR PAINTING  
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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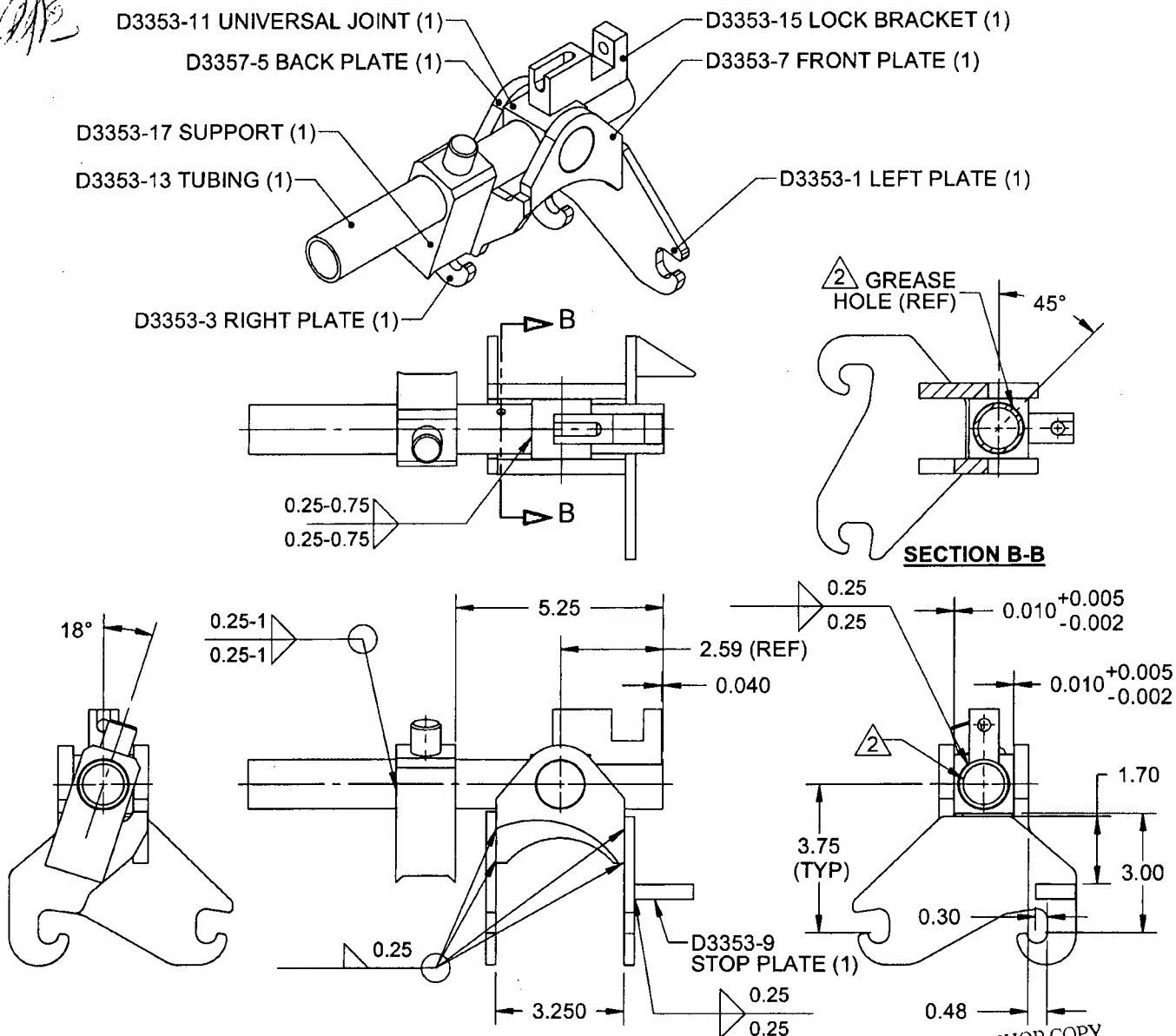
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:4

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06/03/59



### D3353-042 LUG WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

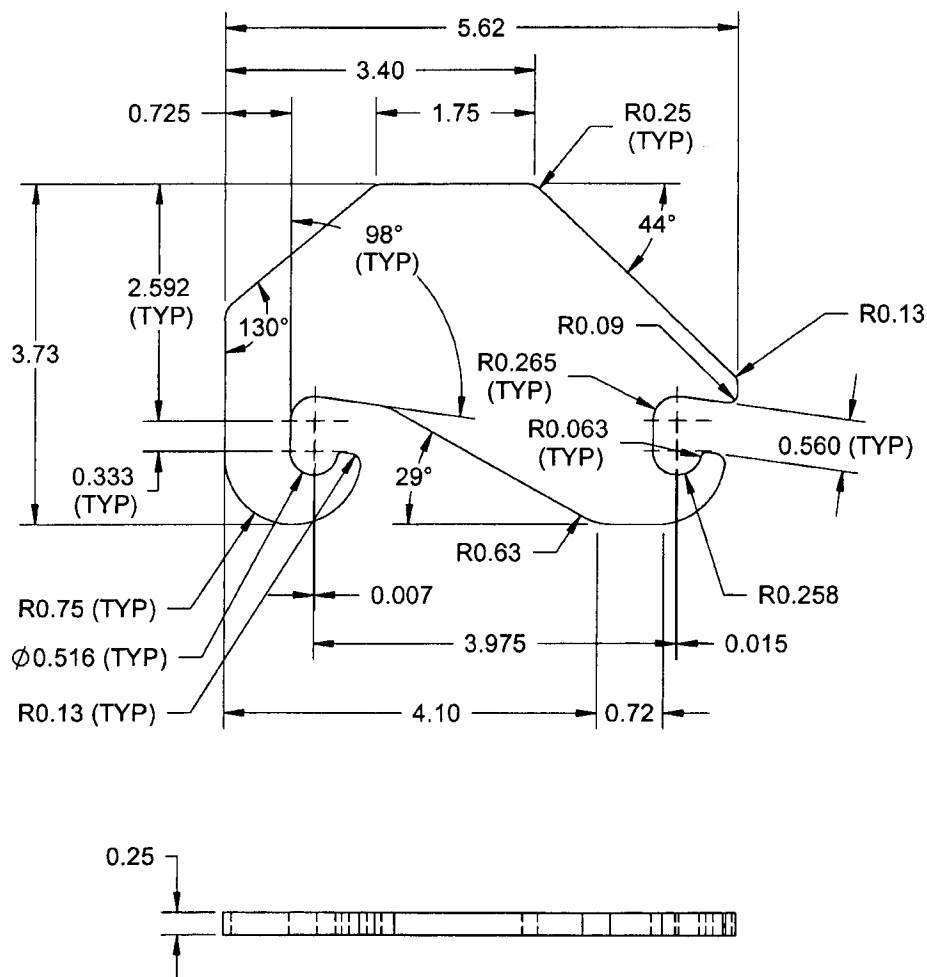
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*[Signature]***D3353-1 LEFT PLATE****NOTES:**

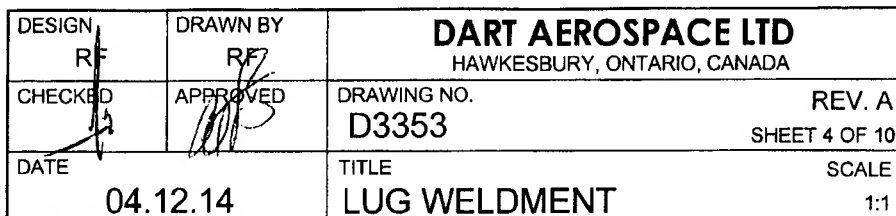
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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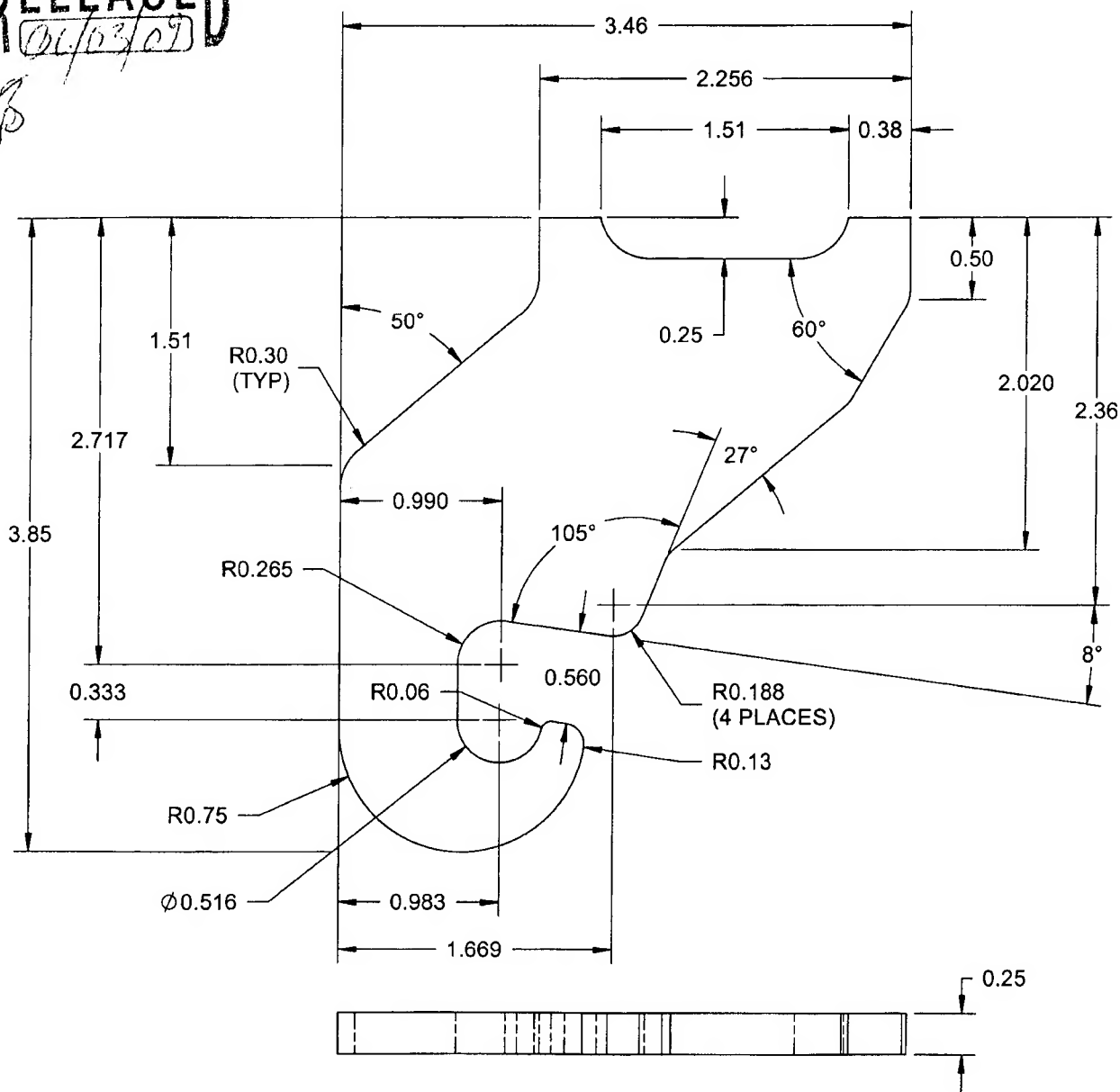
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01/03/09



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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,  
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ON CON  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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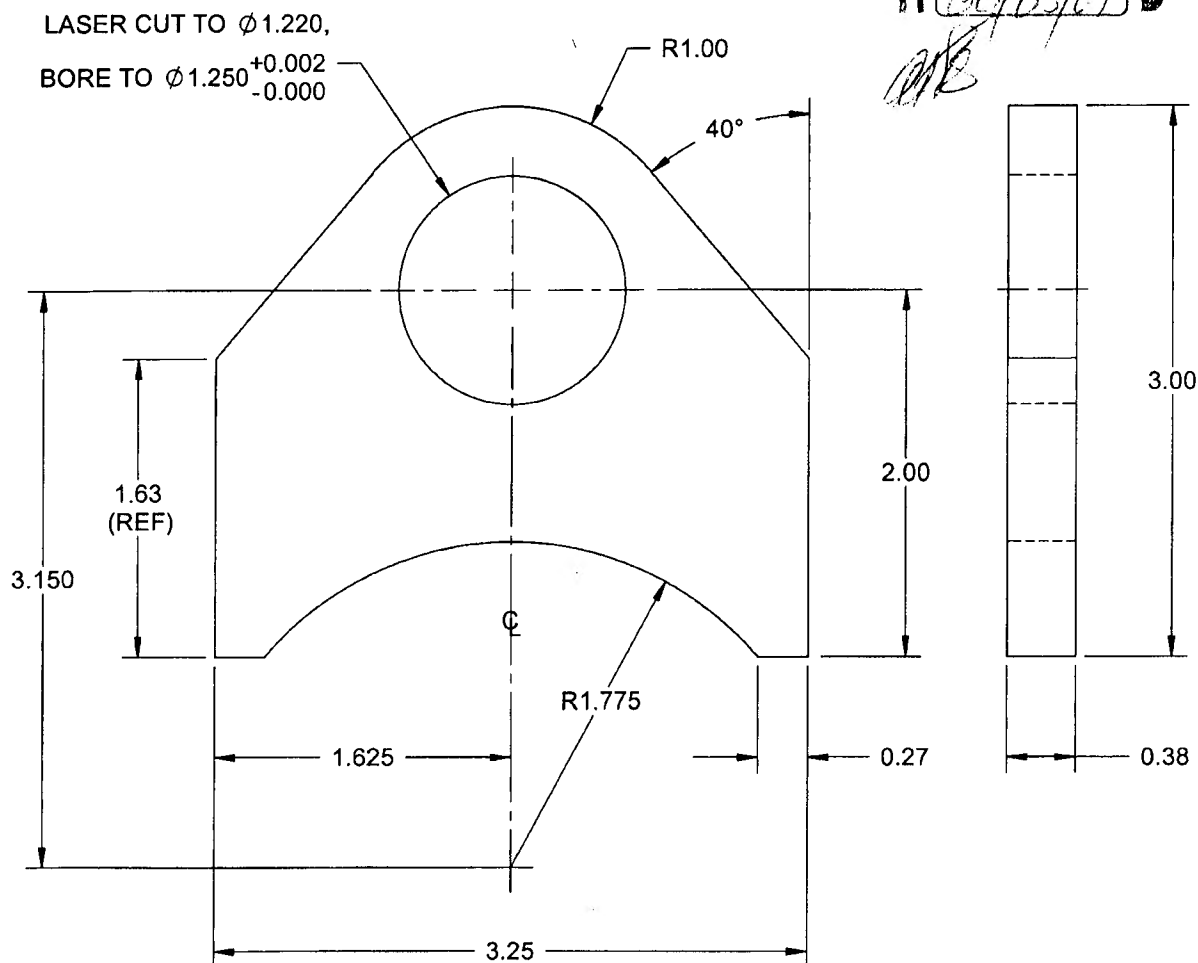
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06/03/09



### D3353-5 BACK PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

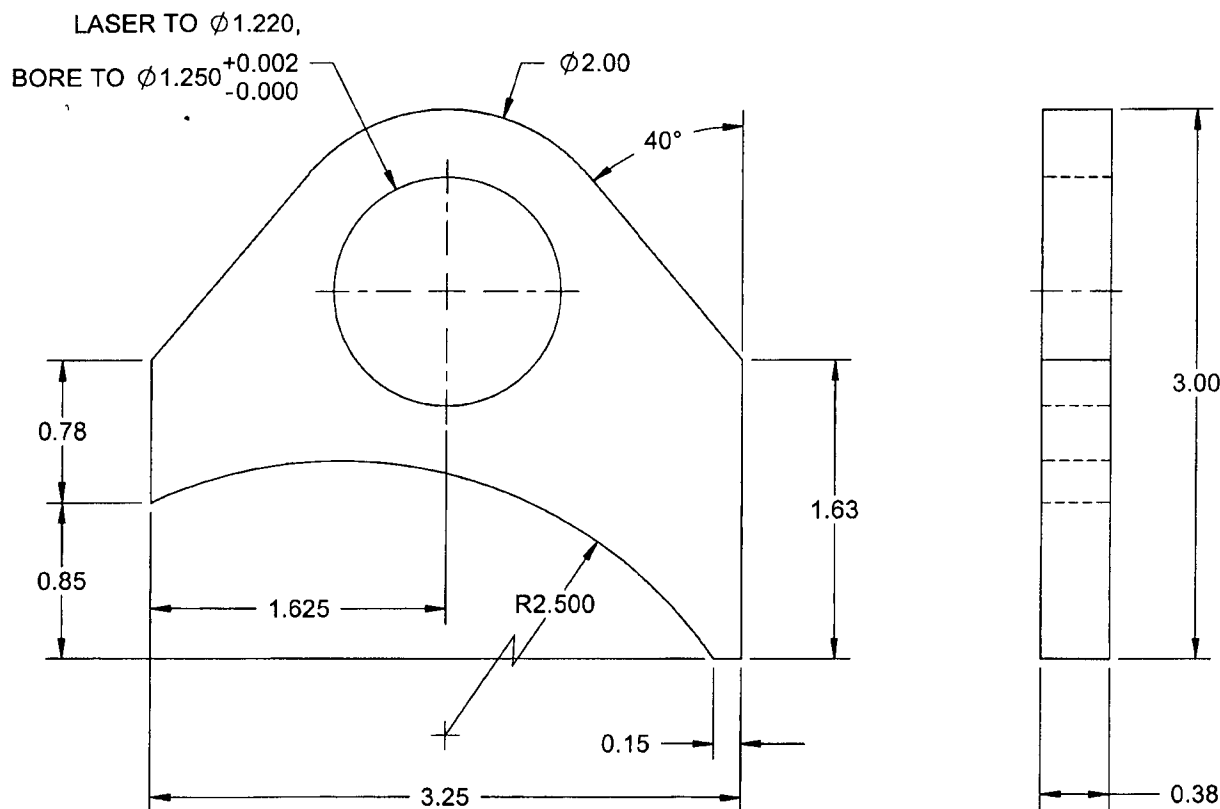
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1

**RELEASED**  
06/01/07**D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES  
STEEL 0.375 THICK PLATE  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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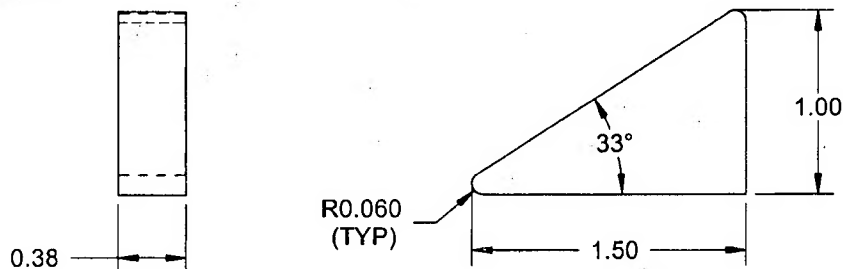
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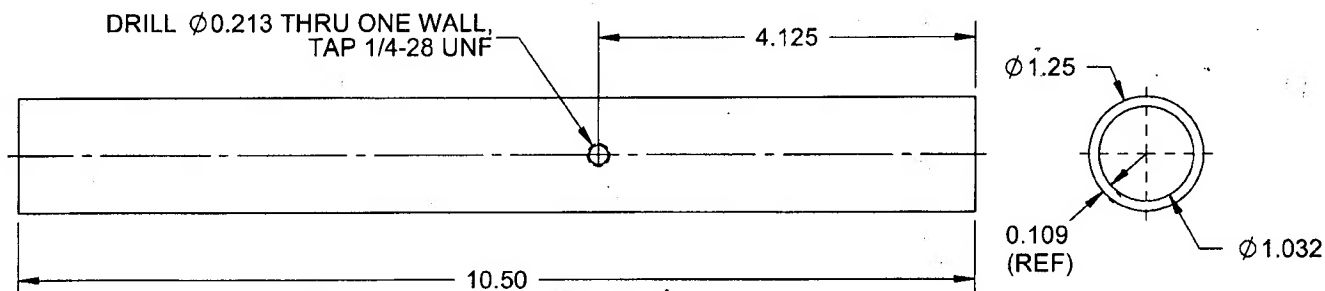
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

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22/33/04

[Signature]

**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK  
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING  
(REF. DART SPEC. M1020TR1.250W.109)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

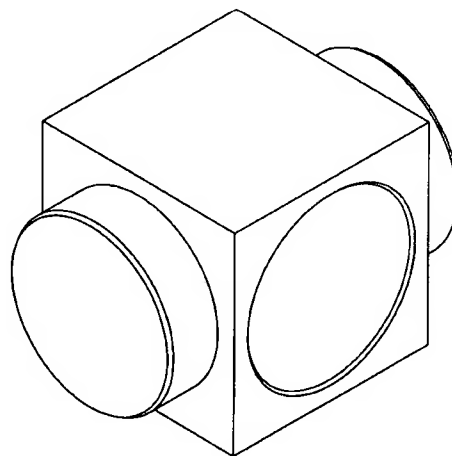
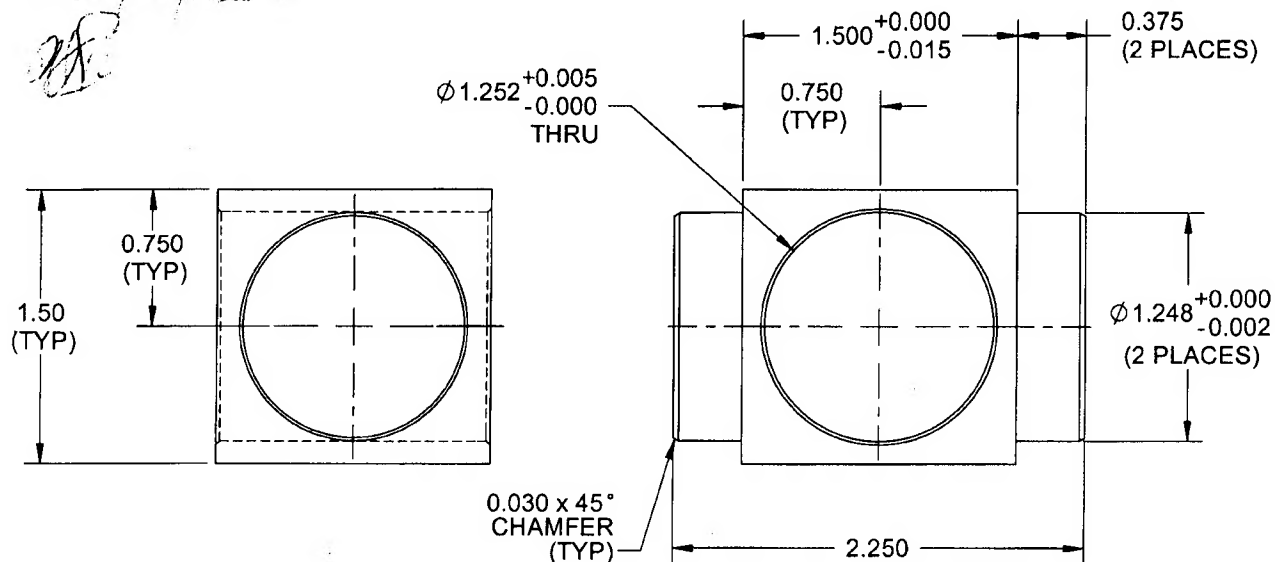
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>		SCALE 1:1

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04/30/09  
[Signature]**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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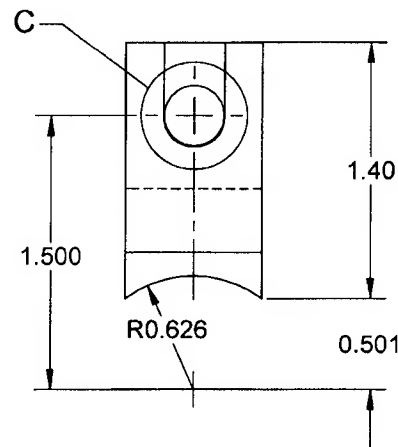
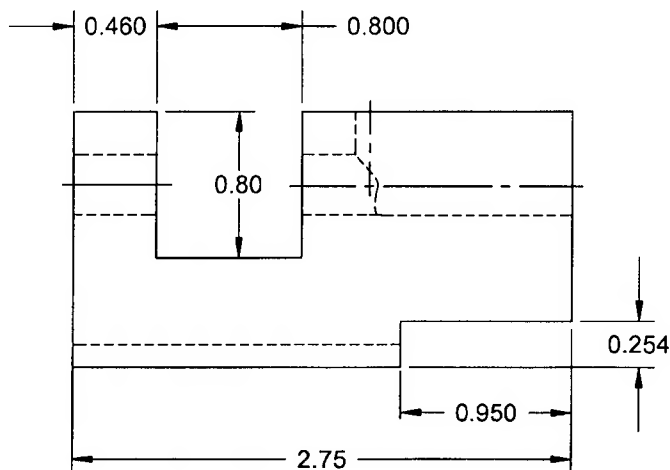
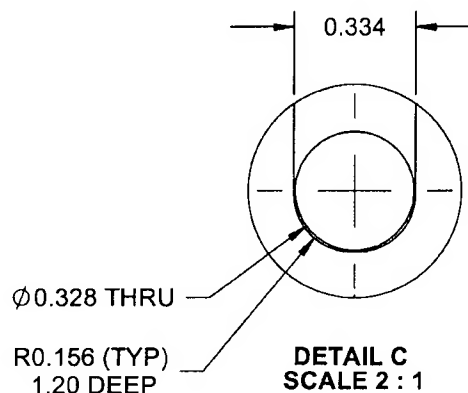
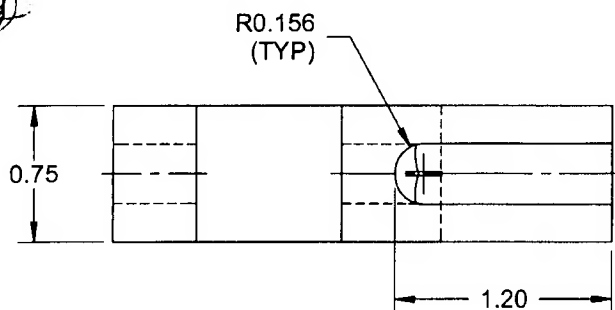
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

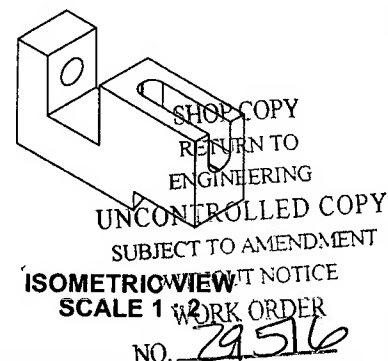
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### D3353-15 LOCK BRACKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

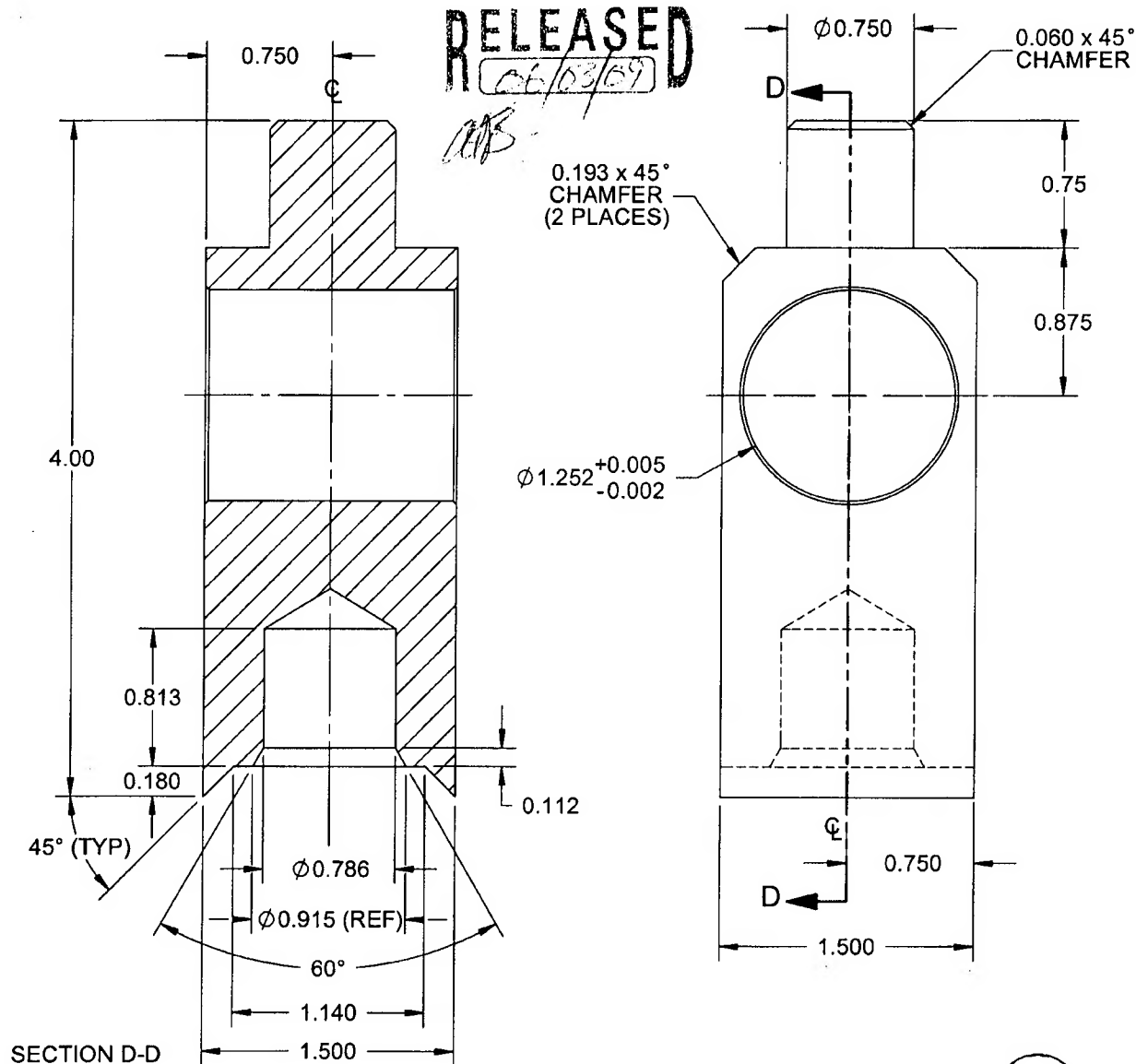


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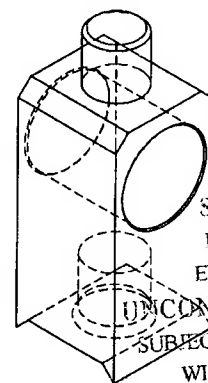
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DATE <b>04.12.14</b>	TITLE <b>LUG WELDMENT</b>	SHEET 10 OF 10 SCALE 1:1	

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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